

Dart Aerospace Ltd.

Date: Wednesday, 15/10/2008 2:43:58 PM
User: Linda Lapelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : DRAIN TUBE ASSEMBLY
Job Number : 42608
Estimate Number : 12622
P.O. Number :
This Issue : 15/10/2008 S.O. No. :
Print Rev. : NC Part Number : D2127251913
First Issue : 11 Type : SMALL /MEO FAB Drawing Number : D212-725-1 PG28
Previous Run : 39877 Material : N/A
Written By : Due Date : 22/10/2008 Qty: 1 Um: Each
Checked & Approved By :
Comment : Est Rev:A New Issue 07-01-03 JLM

Additional Product

**PRELIMINARY
ISSUE**

Job Number:

PROTOTYPE

Seq. #:

Machine Or Operation:

Description:

1.0

M304TR0750W049

304 RD Tube .750 x .049W



Comment: Qty.: 3.4650 f(s)/Unit Total: 3.4650 f(s)

304SS TUBE .75" X .049" WALL M109115

Batch: M109115 M109314

FF 08/10/17

2.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Form tube as per Dwg D212-725-1 & DT8908 Template

FF 08/10/17

3.0

QCS

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Sostuliz RE

4.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

5.0

QCS

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Sostuliz RE

6.0

AN81812J

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Nut

Batch: M1238

FF 08/10/20

Date: Wednesday, 15/10/2008 2:43:59 PM
 User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DRAIN TUBE ASSEMBLY

Job Number: 42608

Part Number: D2127251913

Job Number:

Seq. #:

Machine Or Operation:

Description:

7.0

MS2081912J

Sleeve

Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Sleeve

Batch:

M103179

FF 08/10/20 ①

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1

Comment: SMALL & MEDIUM FAB RESOURCE 1

Install sleeves & nut then flare tube as per Dwg D212-725-1.

FF 08/10/20 ①

9.0

QC5

INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP

08.10.20
08.10.28

10.0

PACKAGING 1

PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

Ship to Roberto

08.10.28



11.0

QC21

FINAL INSPECTION/W/O RELEASE

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

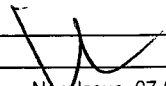

POSITIVE RECALL

EFFECTIVE 08/10/20 AUTH

RELEASED 08/10/20 DATE 08.10.29

Date: Wednesday, 15/10/2008 2:43:58 PM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : DRAIN TUBE ASSEMBLY
Job Number : 42608	
Estimate Number : 12622	
P.O. Number :	Part Number : D2127251913
This Issue : 15/10/2008 S.O. No. :	Drawing Number : D212-725-1 PG28
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : E
Previous Run : 39877	Material :
Written By : 	Due Date : 22/10/2008 
Checked & Approved By :	Qty: 1 Um: Each
Comment : Est Rev:A New Issue 07-01-03 JLM	

Additional Product

Job Number:

**PROTOTYPE**

Seq. #:	Machine Or Operation:	Description :
1.0	M304TR0750W049	304 RD Tube .750 x .049W



Comment: Qty.: 3.4650 f(s)/Unit Total: 3.4650 f(s)

304SS TUBE .75" X .049" WALL M109115

Batch: M109115 M109314

FF 08/10/17

①

2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

Form tube as per Dwg D212-725-1 & DT8908 Template

FF 08/10/17

①

3.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

S 08/10/17

4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
-----	-----------------	----------------------------



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

S 08/10/17

5.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
-----	-----	---



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

S 09/10/17

6.0	AN81812J	Nut
-----	----------	-----



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Nut

Batch: M1238

FF 08/10/20

①

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DRAIN TUBE ASSEMBLY

Job Number: 42608

Part Number: D2127251913

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

MS2081912J

Sleeve



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Sleeve

Batch: M103179

FF 08/10/20 ①

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install sleeves & nut then flare tube as per Dwg D212-725-1.

FF 08/10/20 ①

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08.10.20 ①

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Ship to Roberto



C 20810/20 ① ship to Roberto on 20 oct 08
felix

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



POSITIVE RECALL

EFFECTIVE 08/10/20

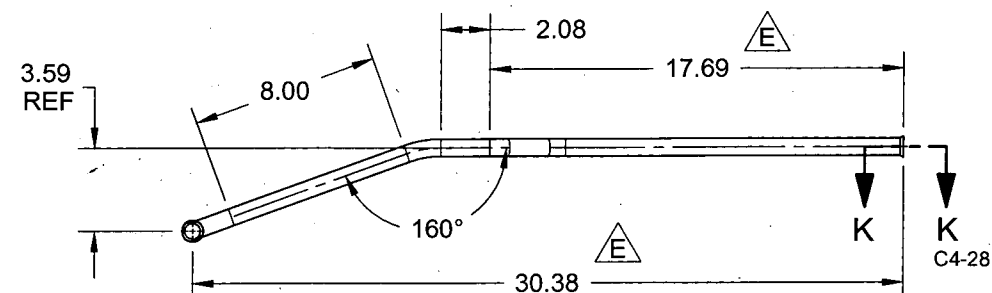
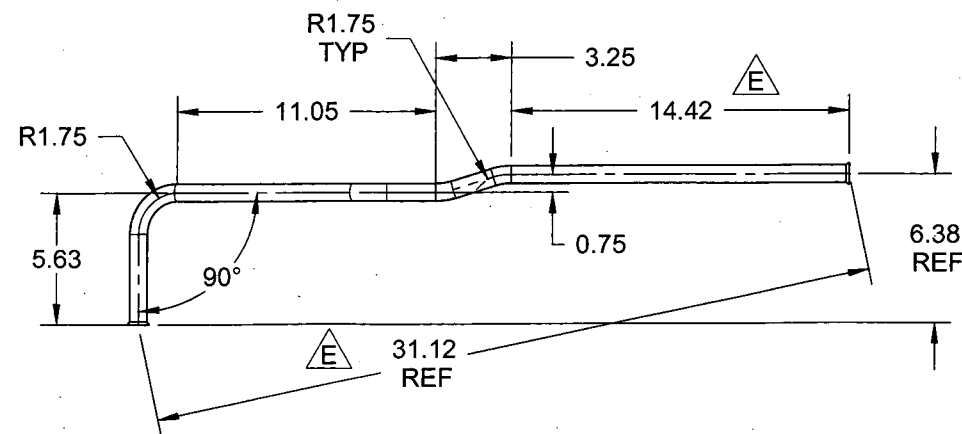
AUTH

RELEASED

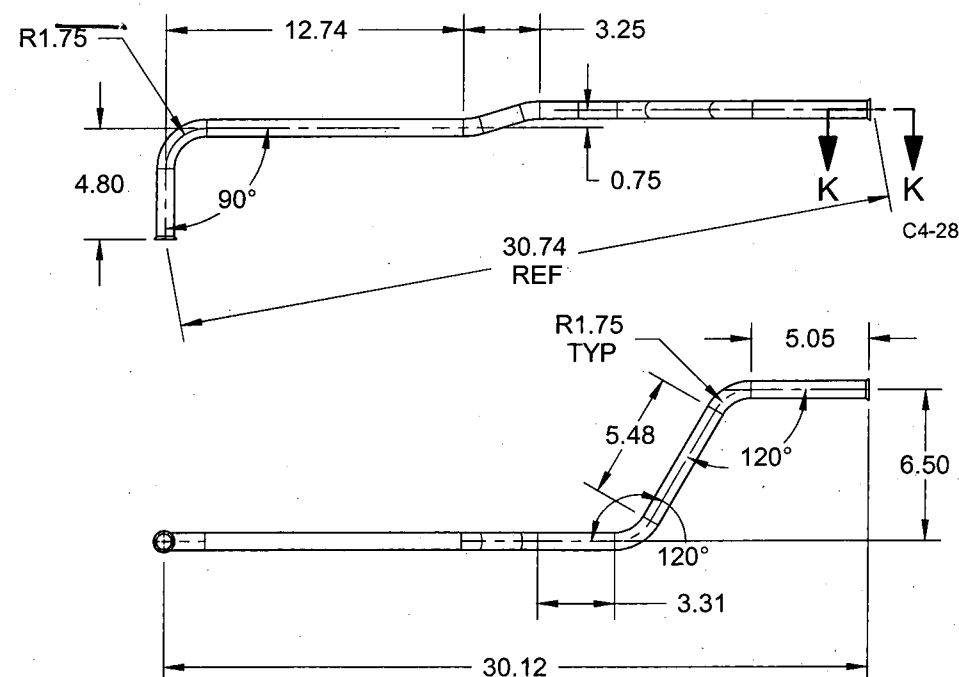
08/11

DATE

08.10.29



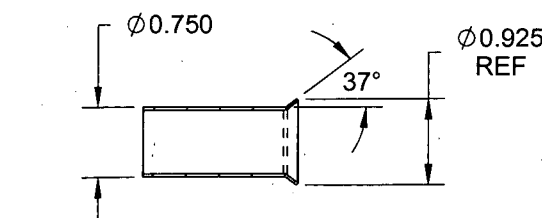
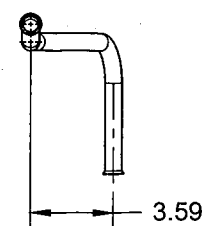
D212-725-1-071 DRAIN TUBING
MANUFACTURE PER TEMPLETE DT8908



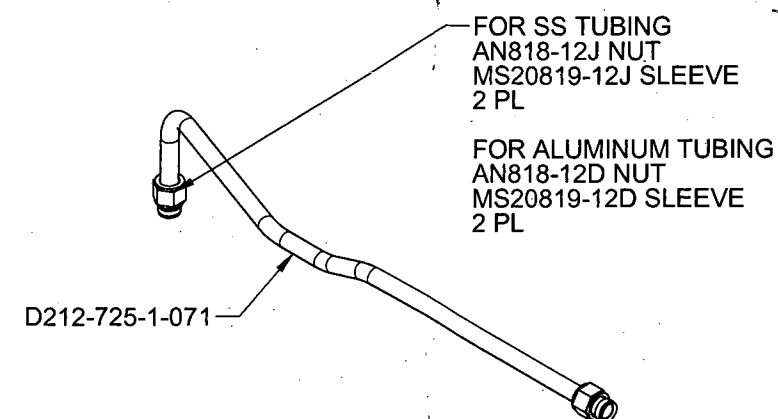
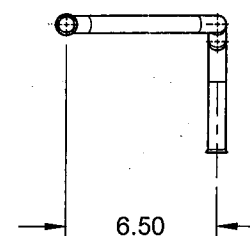
D212-725-1-073 DRAIN TUBING
MANUFACTURE PER TEMPLATE DT 8909

D212-725-1-071/-073:

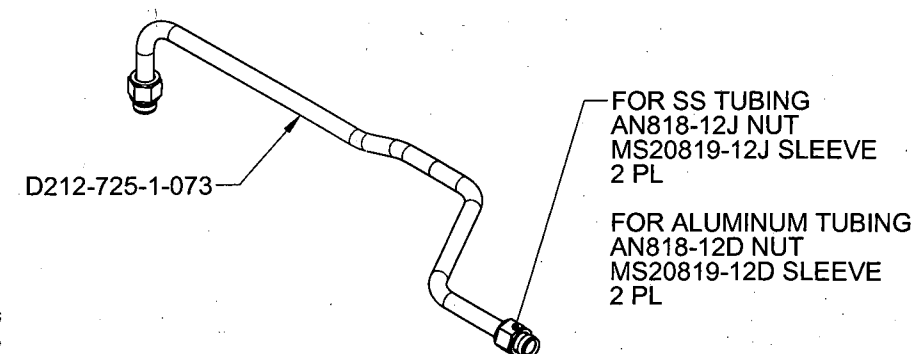
- 1) MATERIAL: AISI 304/316 SS $\varnothing 0.750 \times 0.049$ WALL SEAMLESS ROUND TUBING (REF. DART SPEC. M304TR0.750W.049) OR 6061-T6 OR 6061-T62 ALUMINUM TUBING $\varnothing 0.750 \times 0.035$ WALL (REF. DART SPEC. M6061T6TR0.750W0.035)
- 2) FINISH: FOR ALUMINUM TUBING ACID ETCH, ALODINE 1200 OR 1201 PER MIL-C-5541
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY ASSEMBLY (-913/-915) WITH DART P/N USING FINE POINT PERMANENT INK MARKER



SECTION K-K
(FINISH FLARE ONE END AFTER ASSEMBLY)
SCALE 2X



D212-725-1-913 DRAIN TUBE ASSY



D212-725-1-915 DRAIN TUBE ASSY

**PRELIMINARY
ISSUE**
08/10/30
PROTOTYPE

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DS	DRAWING NO.	REV. E
MFG. APPR.	N/A	D212-725-1	SHEET 28 OF 81
APPROVED		TITLE	SCALE
DE APPR.		212S DETAIL PARTS	NTS
DATE	08.09.17	COPYRIGHT © 2006 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

W/O: 42608

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
09/10/17	5	1 part was made for use at a Template because measure change M109115	FF	08/10/20			

 Part No: D212-725-1-913 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 42608
Description: Drain tube		Part Number: 0212-725-1-071
Inspection Dwg: 0212-725-1, Rev: E		Page 1 of 1

☒ First Article ☒ Prototype

[illegible]

Measured by:	
Date:	08/07/20

Audited by:	
Date:	06.10.20

Prototype Approval:	
Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

L Lacelle

From: Roberto Fuentes [rfuentes@dartaero.com]
Sent: October 28, 2008 8:55 AM
To: 'L Lacelle'
Subject: RE: tubes

There all 3 tubes are ok. I will send to you today template and the previous w/o. I will call you in few minutes.

Roberto

From: L Lacelle [mailto:llacelle@dartaero.com]
Sent: Tuesday, October 28, 2008 5:34 AM
To: 'Roberto Fuentes'
Subject: tubes

Hi Roberto,
Any news on the tubes???

Thank You,
Linda Lacelle
Production Manager
Dart Aerospace Ltd